

# Work Order ID 60150

Monday, June 28, 2010 9:13:36 AM

Page 1

Item ID: D2221

Accept

Setup Start

Revision ID:

Stop

Item Name: 350 Basket Base

Start Date: 6/28/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 7/9/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date: 6/28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221  
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221  
3- tack weld mesh on basket as per dwg D2221  
A/R ER316 S.S. Rod Batch: 111679

*CP 1007.07*

110

QC9- Inspect visual per QS1004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

*PD 1007.08*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_








NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				




**NOTE:** Date & initial all entries

# Work Order ID 60150

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Page 2

Item ID:	D2221	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	350 Basket Base					
Start Date:	6/28/2010	Start Qty:	1.00		Cust Item ID:	
Required Date:	7/9/2010	Req'd Qty:	1.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						
						

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00 0.00		Sw/07/08					
130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel  Memo 1- Plug holes prior to  1ST COAT: START TIME: 9:30 OVEN TEMPERATURE: 400° FINISH TIME: 10:00 ***** 2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00							

① BR 10-7-9.

① BR 10-7-9

W/O:		WORK ORDER CHANGES						
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**Work Order ID 60150**

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Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 6/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/9/2010 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00							
			= 7m. / 10/07/13			(1X)			
150  Packaging Packaging	Identify as per dwg & Stock Location  Memo	0.00 0.00							
			GA 10/07/13			(1)			
160  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							

10-7-13

MF  
10-7-13

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**NOTE:** Date & initial all entries

# Picklist Print

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Monday, June 28, 2010 9:13:41 AM

Work Order ID: 60150

Parent Item: D2221

Parent Item Name: 350 Basket Base



Start Date: 6/28/2010

Required Date: 7/9/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM  
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC  
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC  
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1  Rib		Manufactured	No			100	Each	12.0000	1	1			
<div> <div>Location</div> <div>WA</div> <div>58122</div> <div>59275</div> </div> <div> <div>Loc Qty</div> <div>12</div> <div>1</div> <div>11</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2221-5  Rib		Manufactured	No			100	Each	8.0000	2	2			
<div> <div>Location</div> <div>WA</div> <div>59843</div> </div> <div> <div>Loc Qty</div> <div>8</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2221-7  Rib		Manufactured	No			100	Each	0.0000	1	1			
<div> <div>Location</div> <div>WA</div> <div>59843</div> </div> <div> <div>Loc Qty</div> <div>8</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2232-3  Basket Hinge		Manufactured	No			100	Each	0.0000	2	2			
<div> <div>Location</div> <div>WA</div> <div>59267</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D2235-1  Basket Rib		Manufactured	No			100	Each	4.0000	2	2			
<div> <div>Location</div> <div>WA</div> <div>59267</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

lpl 10.07.07

lpl 10.07.07

B59981 → ① lpl 10.07.07

B59924 → ③ lpl 10.07.07

B59925 → ② lpl 10.07.07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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# Picklist Print

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Monday, June 28, 2010 9:13:41 AM

Work Order ID: 60150

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 6/28/2010

Required Date: 7/9/2010

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

27.0000

2

2



Mounting Bracket

Location

Loc Qty

Loc Code

ST

1

59121

1

WA

26

46086

2

51745

2

57185

1

59265

21

100

Each

12.0000

2

2

D3442-1

Manufactured No



Shim

Location

Loc Qty

Loc Code

WA

12

58028

12

100

Each

4.0000

2

2

D3825-041

Manufactured No



Rib Assembly (Basket End)

Location

Loc Qty

Loc Code

WA

4

59844

4

100

Each

4.0000

2

2

D3826-041

Manufactured No



Rib / Gusset Assembly

Location

Loc Qty

Loc Code

WA

4

59730

4

Monday, June 28, 2010 9:13:41 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

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Monday, June 28, 2010 9:13:41 AM

Work Order ID: 60150



Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 6/28/2010

Required Date: 7/9/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3827-041

Manufactured No

100

Each

3.0000

1

1



Rib Assembly (Inboard)

Location

Loc Qty

Loc Code

WA

3

59276

3

100

Each

5.0000

1

1



①

*PL 10-07-07*

✗ D3832-1

Manufactured No



Mesh (Base)

Location

Loc Qty

Loc Code

WA

5

59341

2

60132

3

100

Each

11.0000

2

2



1

*SAD 10-07-07*

✓ D3833-1

Manufactured No



Mesh (Base End Face)

Location

Loc Qty

Loc Code

WA

11

56396

1

59184

2

59902

8

①

*PL 10-07-07*

Monday, June 28, 2010 9:13:41 AM

Shop Packet Print

Page 3

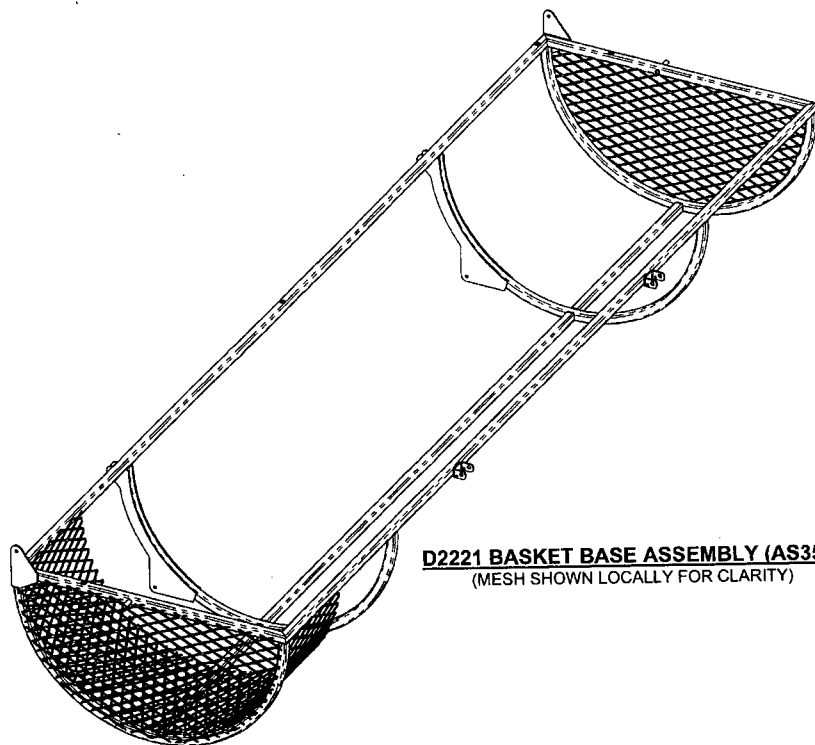
W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries



**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 60150  
*BS10-6-21*

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

**RECEIVED**  
08/11/18

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN D6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 58.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARAT. BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. H
CHECKED		D2221	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET BASE ASSEMBLY (350)	NTS
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.09.18		

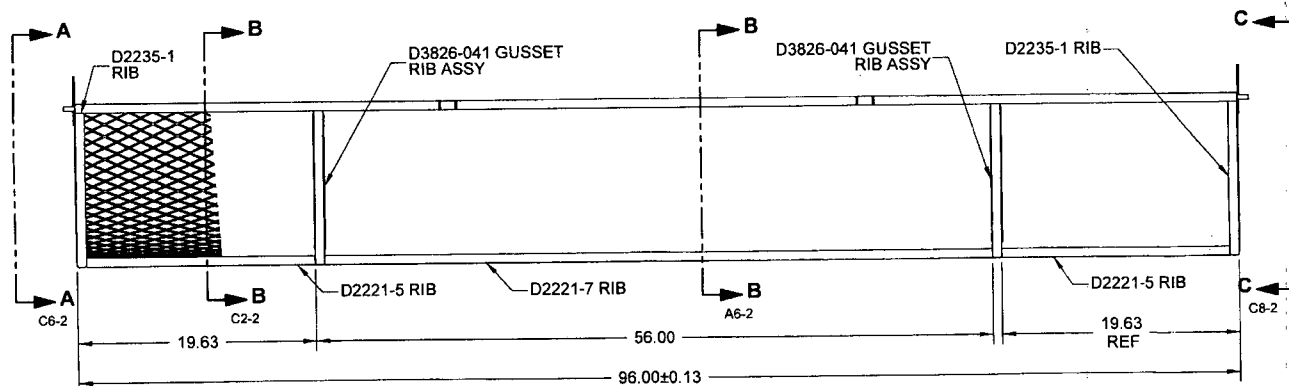
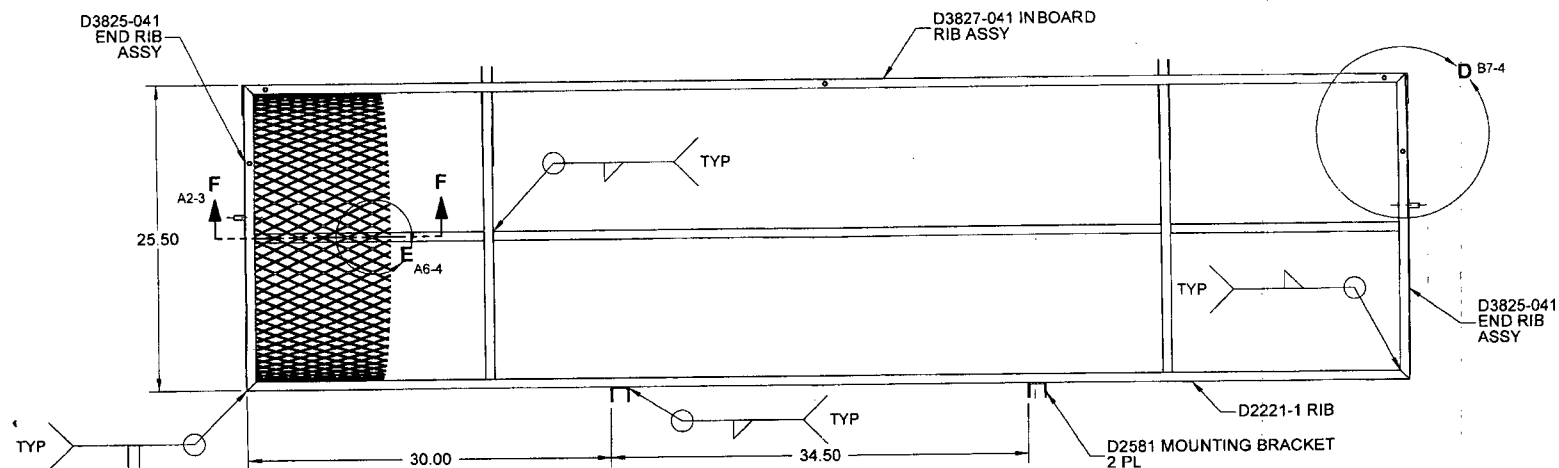
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**D2221 BASKET BASE ASSEMBLY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
06/11/18 NAD

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. H
CHECKED		D2221	SHEET 2 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET BASE ASSEMBLY (350)	NTS
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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u/b 60150

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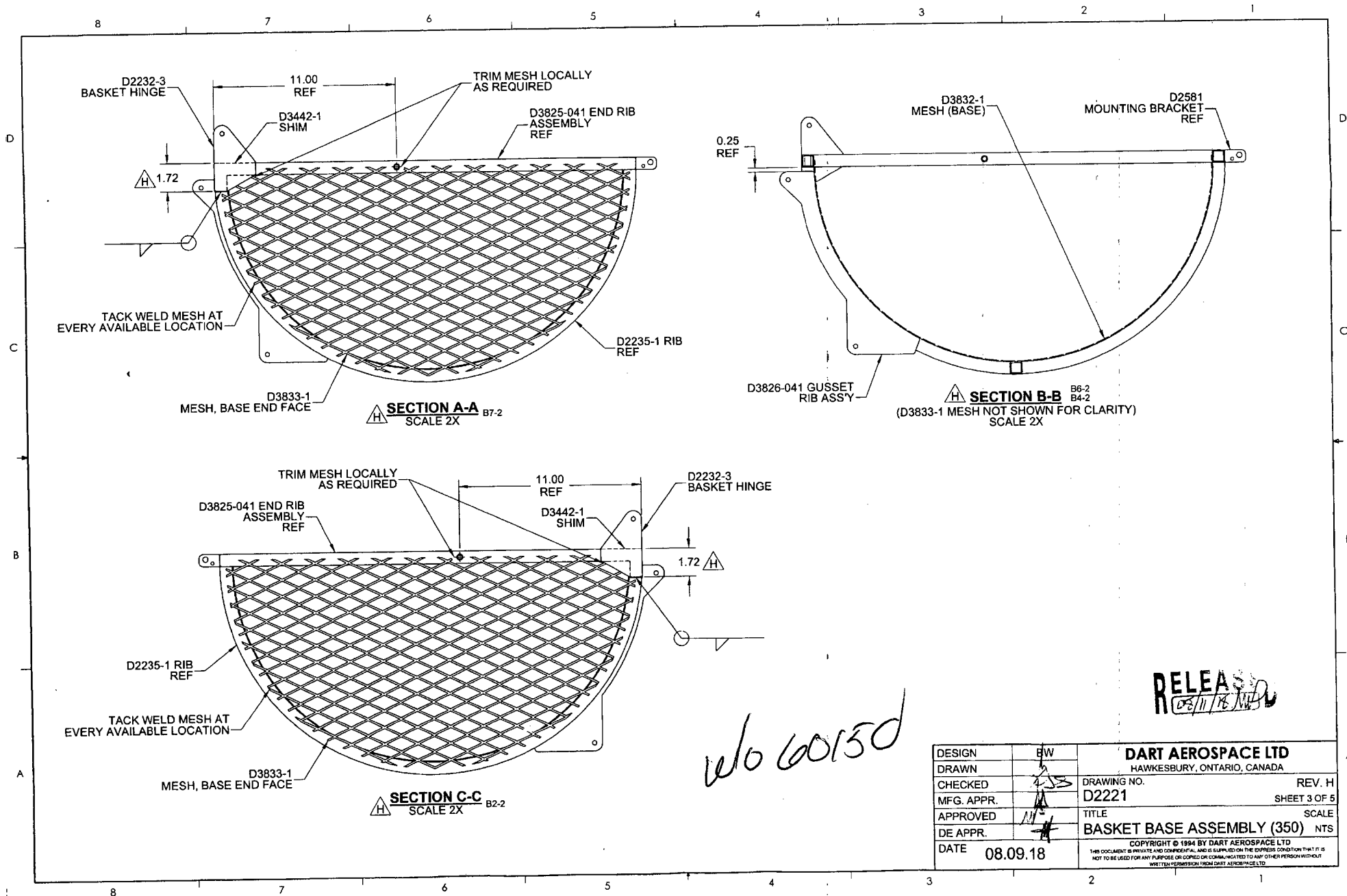
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**NOTE:** Date & initial all entries





RELEASED  
03/11/16

W660150

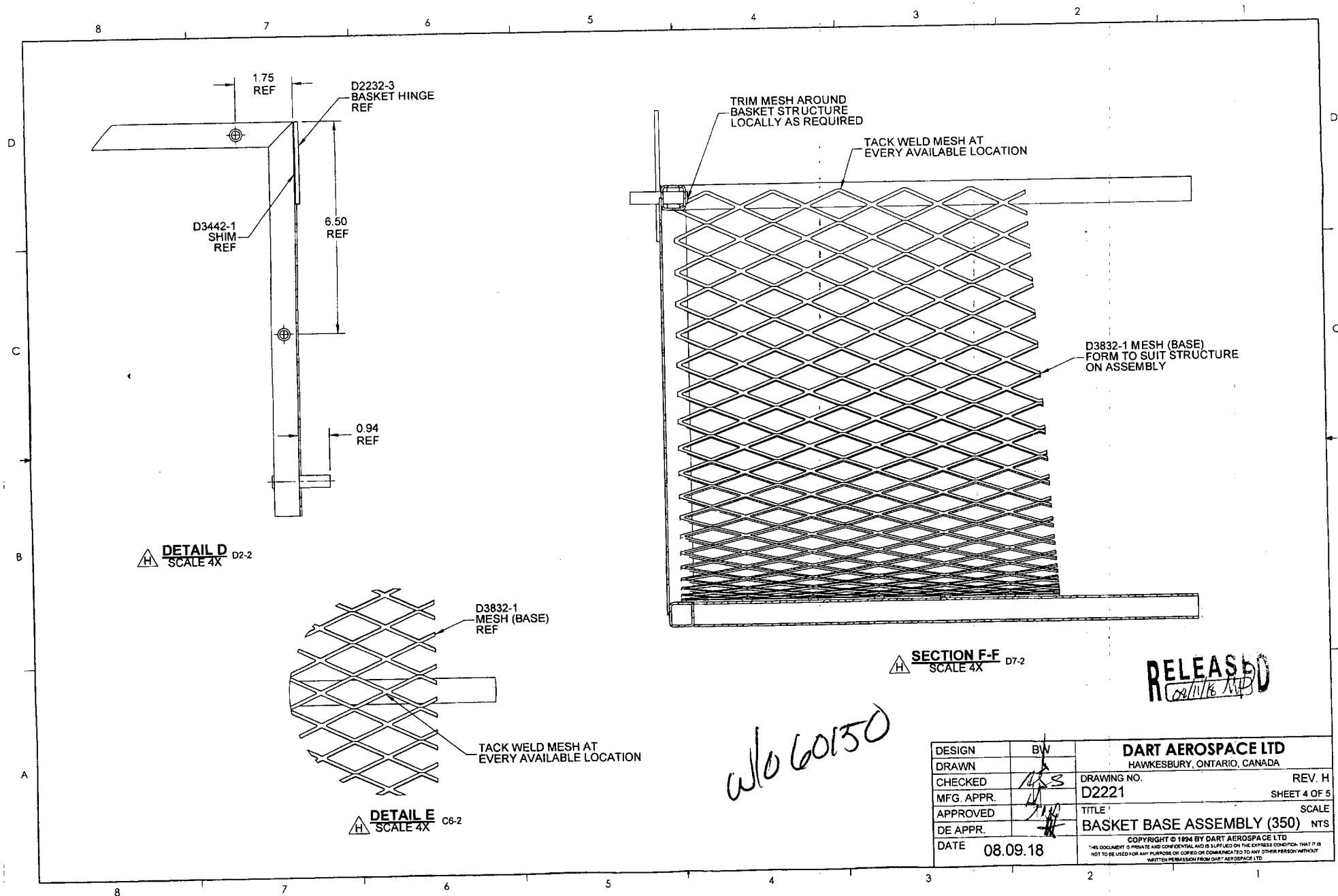
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DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2221	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>BASKET BASE ASSEMBLY (350) NTS</b>	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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**Dart Aerospace Ltd**

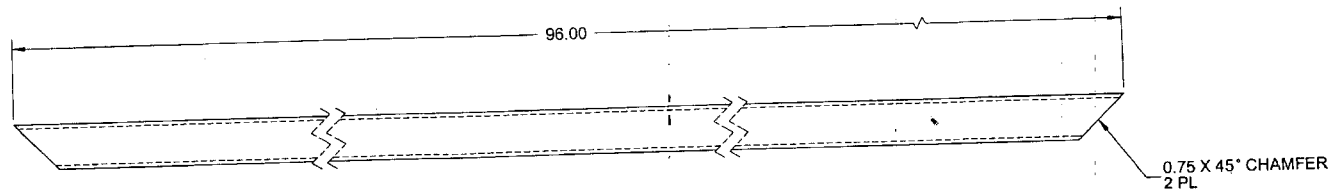
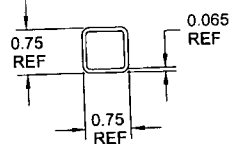
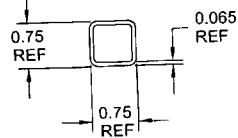
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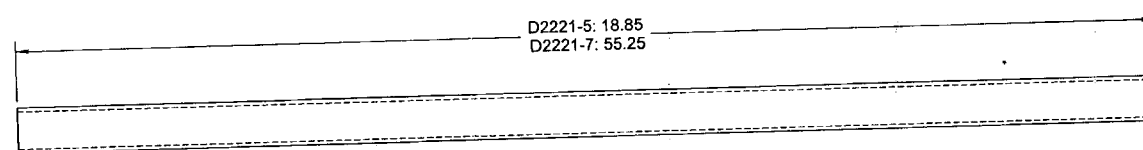
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**D2221-1 RIB**



**D2221-5/-7 RIB**

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

*wlo 60/50*

**RELEASED**  
08/11/18

DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D2221</b>	REV. H
MFG. APPR.		SHEET 5 OF 5	
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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries